

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022229**Date Inspected:** 01-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 3

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on Architecture Housing sub-assembly. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Zhi Jiang. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20328

Weld- AH3150-002,003

WPS-345-SMAW-1G(1F)-Repair

Welder-058102

Bay 1

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on traveler rail assemblies. ZPMC CWI Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

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Weld-20TR2-038-009, 013
WPS-B-T-2231-ESAB
Welder-204342, 053609
1G/FCAW/CJP

Weld-20TR2-037-017
WPS-B-T-2231-ESAB
Welder-217185
1G/FCAW/CJP

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding. ZPMC QC inspector Li Jun was present at this time of this observation and informed this QA inspector of the work that is in process and identified Guo Yan Fei as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-27TR1
WPS-B-P-2114
Welder-052889
4F/Tack Welding Flange to Web

Bay 11

This QA inspector observed ZPMC in process of welding on traveler rail assemblies, Tower Head Cover and Bike Path Assembly. ZPMC QC inspector Mao Bin Bin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI. It was stated that ZPMC had 5 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-035-009
WPS-B-P-2211-TC-U5b
Welder- 044541
1G/SMAW/CJP

Weld- 20TR2-035-013
WPS-B-P-2211-TC-U5b
Welder- 040611
1G/SMAW/CJP

Weld- 20TR2-035-015
WPS-B-P-2211-TC-U5b
Welder- 046769
1G/SMAW/CJP

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Weld- ESD1-TPSA6-2-54
WPS-B-T-2233-ESAB
Welder- 040784
1G/FCAW/CJP

Weld- BK008A2-021
WPS-B-P-2112
Welder- 052641
2F/SMAW

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
